

Work Order ID 57161

March 24, 2010 8:44:19 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 24/03/2010 Start Qty: 1.00

Required Date: 07/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-3-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DOCUMENT CONTROL

DC:

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Stop



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Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod M112507/M113207

BE 10-3-30

4-Grind weld flush to cap on top surface only.

BE 10-3-30

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

DP 10-3-30

DP 10-3-30

W/O:		WORK ORDER CHANGES						
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Date:

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Run HoursDraw
NumberDraw
Rev.Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 11/0/3/30

130

Skid tubes

0.00



Skid tubes

Memo

0.00

Skid tubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting

Start Date: 10/03/10 Time: 2:30

Finish Date: 10/03/10 Time: 10:30 AM

A/R: Sikaflex-291 11/2/10

Sikaflex expiry date: 12/3/10

1 11/0/3/30

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

S 10/03/31



QC

Memo

0.00

(X)

Quality Control

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod ☐ M112507

BE 10/03/31

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

4- Install nut plate as per dwg

10-4-6

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

N/A done on seq #150

DP 10-4-6

170

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

Subloc

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Subloc

to

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

bf 10-4-7 ①

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:00AM

=> Jd 10/04/07

x1 Ø

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

①. bf 10-4-19.

W/O:		WORK ORDER CHANGES						
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ M112728Sikaflex expiry date: ☐ 10/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ M112728Sikaflex expiry date: ☐ 10/08

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M113545

BL 10-4-19

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March 24, 2010 8:44:19 AM

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Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Run Start

**Date:**

Tooling:

Date: _____

Date:

SPC (Y/N):

Date: _____

Stop



**Insp.
Stamp**

0.00



0.00

0.5012

0.00



0.00

8.104/21

0.00



0.00

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

POPS 7153

④

14/4/20

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27
ME
10-4-27

W/O:		WORK ORDER CHANGES						
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Picklist Print

March 24, 2010 8:44:23 AM

Page 1

Work Order ID: 57161

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube


Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC


Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416		Purchased	No				Each	8.0000	1.0000			
												
Washer												

Warehouse		Loc Qty	Loc Code
Location			
Main Warehouse		113706	
ST357		8	
111279		8	
Each		513.0000	2.0000
CCR264SS3-3			
			
Cherry Rivet			

NAS 1149 DO 463J

1 BR 10-4-20.

Warehouse		Loc Qty	Loc Code
Location			
Main Warehouse			
ST311		513	
111548		16	
111827		1	
112314		2	
113539		6	
113973		488	
Each		236.0000	2.0000
CR3212-4-03			
			
Cherry Rivet			

DP 10-4-6

2

Warehouse		Loc Qty	Loc Code
Location			
Main Warehouse			
ST311		236	
111359		84	
112314		152	

DP 10-4-6

2

W/O:		WORK ORDER CHANGES						
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IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2620	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route	Unit of Each	Qty on 8.0000	Remaining 1.0000	Qty	Date	Status
												
Skidtube, 206 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55559

8

8

Each

87.0000

1.0000



DP 10-3-30

D2647



Cap

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55352

87

87

Each

207.0000

19.0000



BE 10-3-30

D2649



Cross Bolt Spacer

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

207

36013

5

47112

18

48271

4

51529

3

55000

177

★

19 BE 10/03/31

March 24, 2010 8:44:23 AM

Shop Packet Print

Page 2

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2654-5		Manufactured	No				Each	2.0000	1.0000			
Web												

Warehouse
Location

Main Warehouse

LG

46638

Loc Qty

2

2

Loc Code

Each

51.0000

1.0000

11/10/31/50

D2680-041

Manufactured No

Nut Plate

Warehouse
Location

Main Warehouse

ST021

33061

55366

Loc Qty

51

1

50

Loc Code

220

Each

438.0000

54.0000

10-4-6

ALS4-1032-130

Purchased

No

Insert

Warehouse
Location

Main Warehouse

ST282

110511

Loc Qty

438

438

Loc Code

54. BR 10-4-20

March 24, 2010 8:44:23 AM

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 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10L		Purchased	No			220	Each	0.0000	54.0000			
												
washer												
AN960JD10L		Purchased	No			220	Each	3,003.000	2.0000			
												
Washer												

NAS1149C0332R. 113524

56 BK 10-4-20

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST348	3003	
	101291	16	
	105793	49	
	110985 ✓	2938	

D2646	Manufactured	No	220	Each	41.0000	1.0000
						
Aft Cap						

2 BK 10-4-20

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP6	36	
	46327	4	
	48109 ✓	4	
	52663	28	
Main Warehouse	fp7	5	
	52663	5	

1 BK 10-4-20

March 24, 2010 8:44:23 AM

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2651-1		Manufactured	No			220	Each	348.0000	14.0000			

Plug

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

FP

141

51530 ✓

141

Main Warehouse

fpa

207

53349

207

Manufactured No

220

Each

537.0000

14.0000

D2651-3

O-Ring

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

FP

537

43849

3

46114 ✓

534

14 10-4-20.

14 10-4-20.

March 24, 2010 8:44:23 AM

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

March 24, 2010 8:44:23 AM

Page 6

Work Order ID: 57161

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------

D3535-11



Wearshoe

Manufactured

No

Route
220

Unit of
Each

Qty on
6.0000

Remaining
1.0000



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

46647 ✓

6

6

220

Each

14.0000

1.0000



1 BR 10-4-20

D3535-23



Wearshoe

Manufactured

No

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

53467 ✓

56054 ✓

14

2

12

220

Each

9.0000

1.0000



1 BR 10-4-20

D3535-35



Wearshoe

Manufactured

No

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

51608 ✓

9

9

1 BR 10-4-20

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Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March 24, 2010 8:44:23 AM

Page 7

Work Order ID: 57161

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3536-11		Manufactured	No			220	Each	14.0000	1.0000			
												
Gasket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST497A

14

46649 ✓

10

46715

4

D3536-23

Manufactured

No

220

Each

8.0000

1.0000

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

8

30754

1

53468 ✓

7

D3536-35

Manufactured

No

220

Each

11.0000

1.0000

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

11

51628 ✓

11

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Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 57161

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3537-1		Manufactured	No			220	Each	53.0000	6.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 57510 52

48288 2

55465 50

Main Warehouse

FP17 1

51678 1

Manufactured No

220

Each

24.0000

1.0000

D3537-3



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 57512 24

33881 4

35697 20

1 br 10-4-20.

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Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 9

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Work Order ID: 57161



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 24/03/2010

Required Date: 07/04/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-08		Purchased	No			220	Each	2,105.000	56.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST291	2105	
110467	3	
110552	102	
110835 ✓	2000	

MS27039-4-06	Purchased	No				220	Each	38.0000	1.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST292	38	
109061 ✓	38	

56. PR 10-4-20.

1 PR 10-4-20.

March 24, 2010 8:44:23 AM

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31161
10-3-24

RELEASED
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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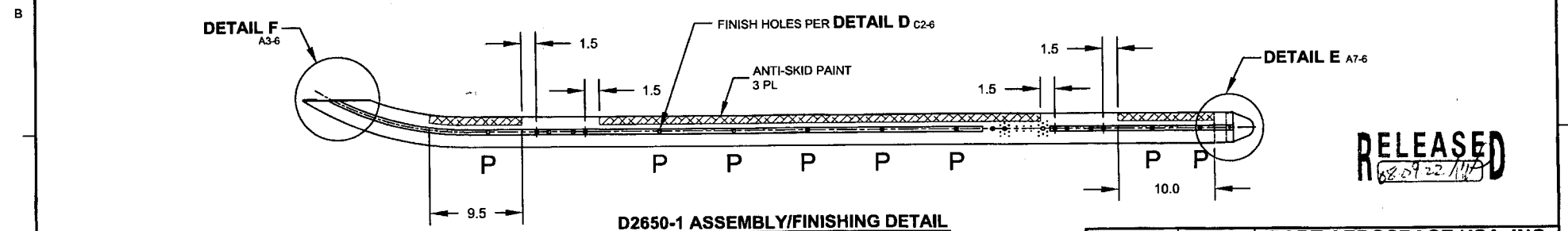
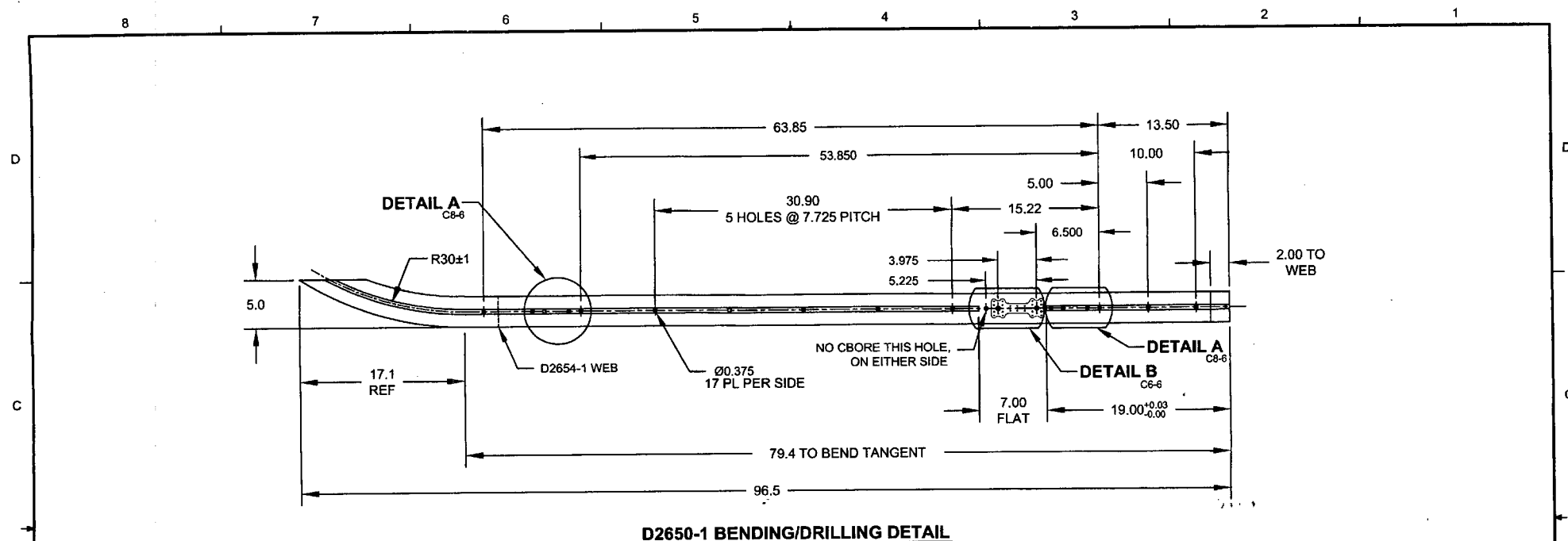
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



57161

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88 09 22 / 117

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MFG. APPR.		D2650	SHEET 2 OF 6
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NOTE: Date & initial all entries

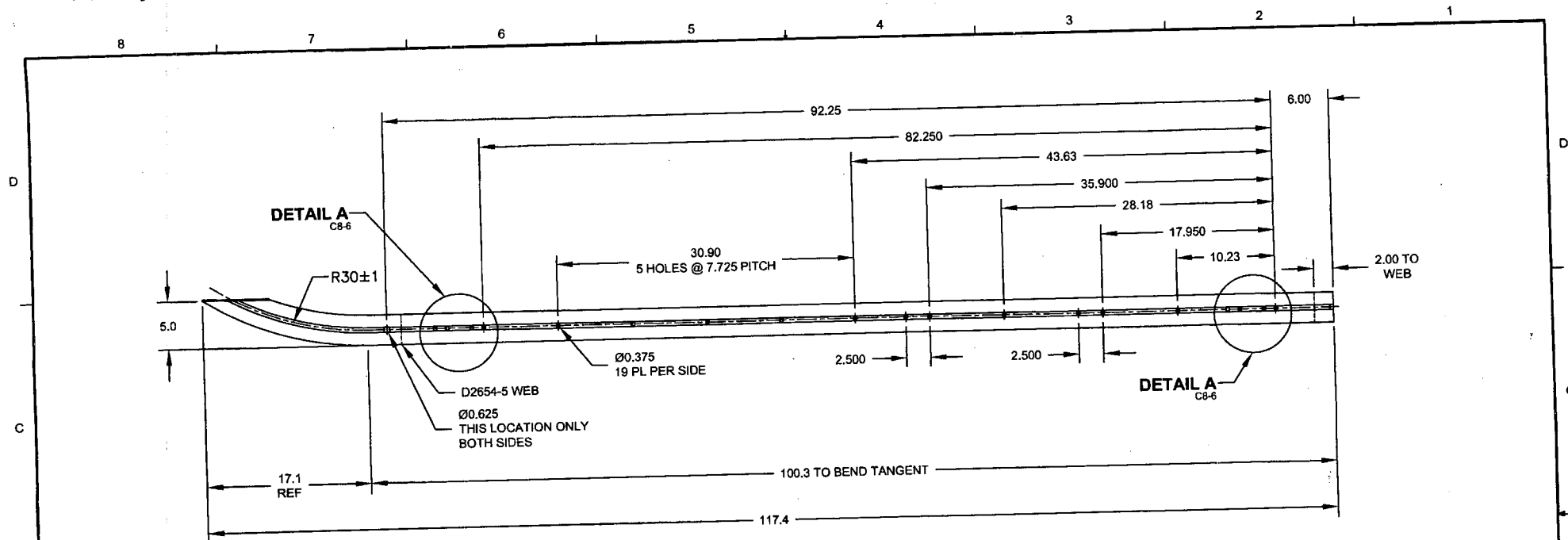
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

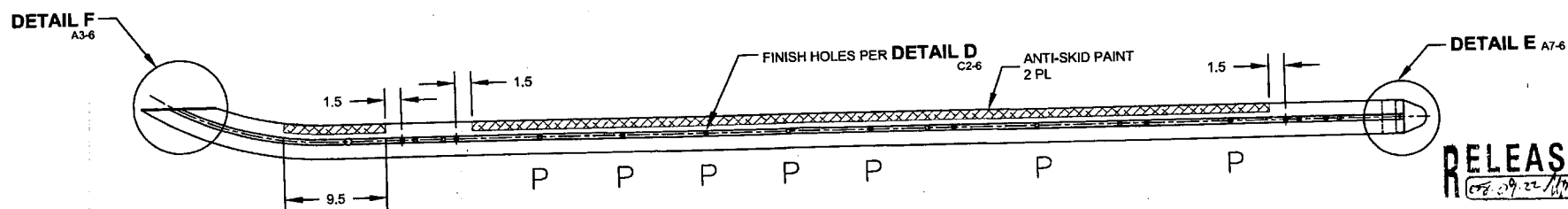
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL

57141



D2650-5 ASSEMBLY/FINISHING DETAIL

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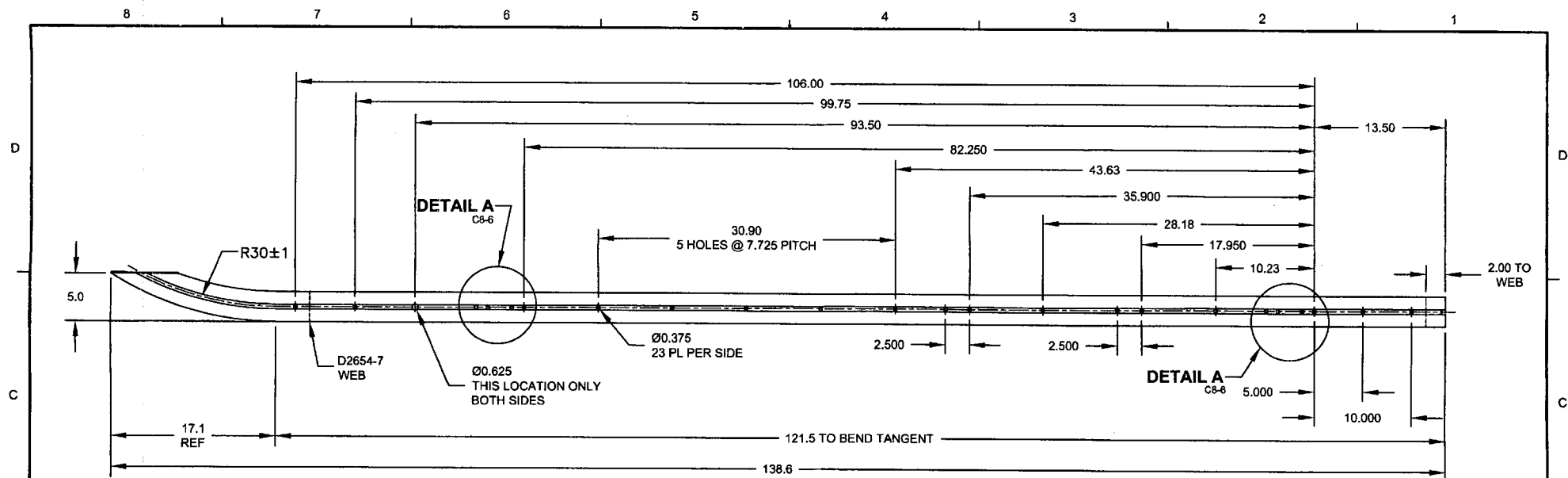
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

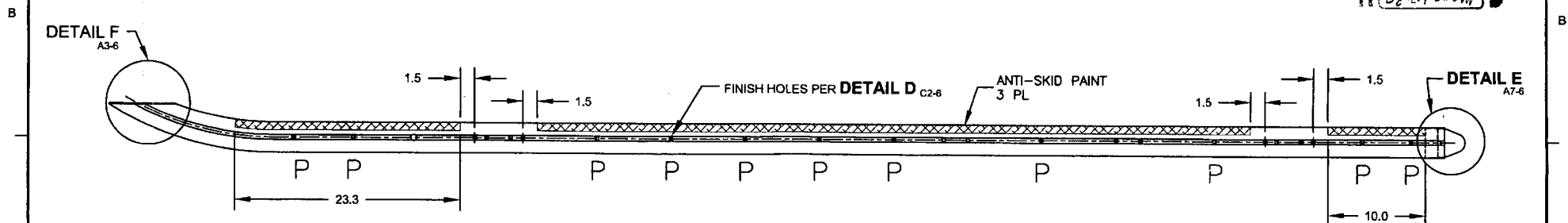
NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL

57161

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D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
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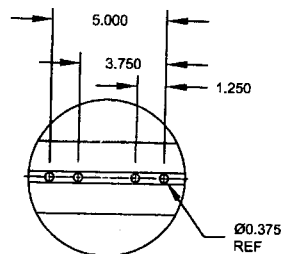
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

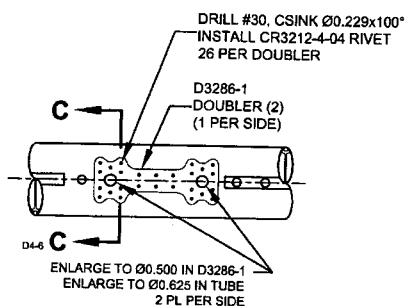
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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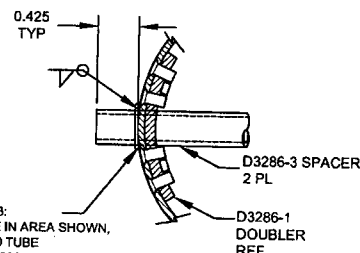


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

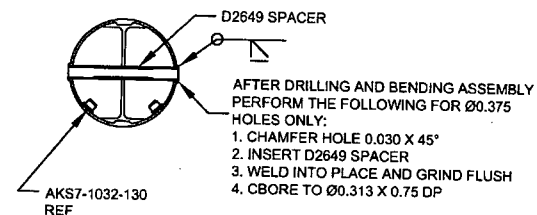


DETAIL B
SCALE 2X
C3-2
C3-3

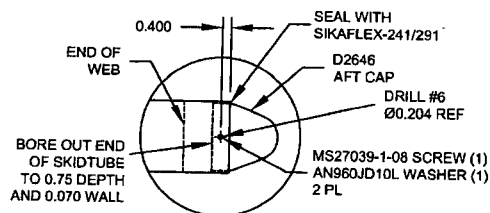
SECTION C-C C7-6
SCALE NONE



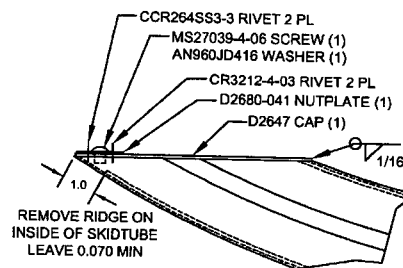
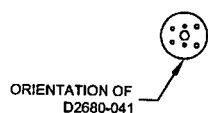
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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05-09-22-18

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 323

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job number: 55777
Part number: 0206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rat. Ind. Date of Test Coupon 10.02.16

Welder Bardley Elliott Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld